

Date: Tuesday, 11/6/2007 1:13:21 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WEARSHOE		
Job Number	35542			Part Number	D265613		
Estimate Number	10314			Drawing Number	D2656 REV D		
P.O. Number				Project Number	N/A		
This Issue	11/6/2007	S.O. No.		Drawing Revision	D		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	11/23/2007	Qty:	20
Previous Run	35207			Um:	Each		
Written By							
Checked & Approved By	<u>07/11/07</u>						
Comment	Est:	F	02.10.25	Re-format KJ/RF			
	Est Rev:G	Now on Waterjet 06-07-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025/A21/6aA SHEET 20.400
		Comment: Qty.: 0.8500 sf(s)/Unit Total : 17.0000 sf(s) 1010/1025/A21/6aA SHEET <u>106069</u> <u>BS 07-11-9</u>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2656 <u>BS 07-11-9</u> Dwg Rev: <u>D</u> <u>BS 07-11-9</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>BS 07-11-9</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>BS 07-11-9</u>
4.0	QC8	SECOND CHECK <u>JAN-11-12 (24)</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	BRAKE NC	NC BRAKE Comment: SECOND CHECK
		Comment: NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158Identify as D2656-13 <u>G. Doyt/13 (24) SP</u>

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35542

Part Number: D265613

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



11/11/13 (24)



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M10S642



(24X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m/f 07/11/13

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(24)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 07-11-13

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(24X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 17

m/f 07/11/14

10.0 QC21

FINAL INSPECTION/W/O RELEASE



07.11.15 (24)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.11.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35542
Description: Wearshoe	Part Number:	D2656-13
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

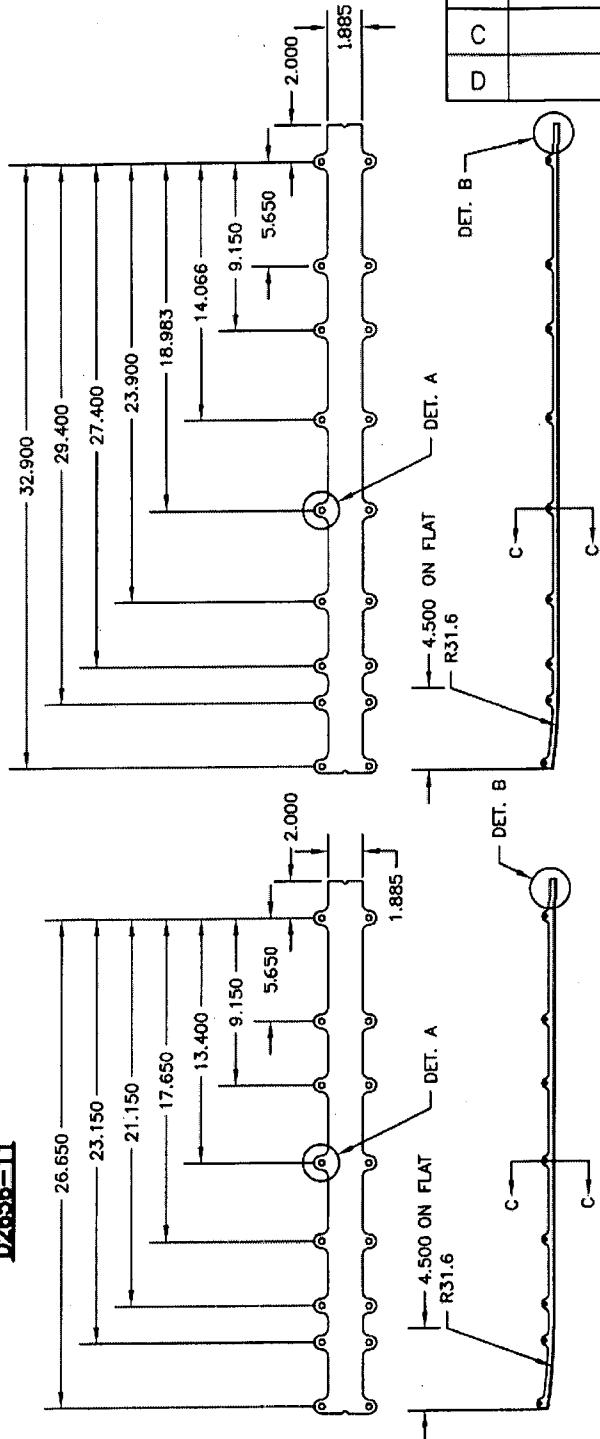
Measured by:	<u>RS</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>01-11-9</u>	Date:	<u>04-11-12</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.05	New Issue	KJ/JLM <i>[Signature]</i>	PZ

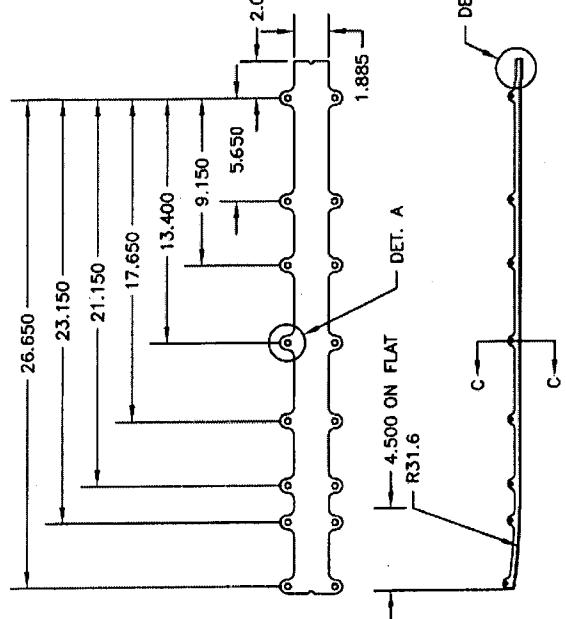
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DS	CP	
CHECKED	APPROVED	DRAWING NO. REV. D D2656 SHEET 1 OF 4
DATE		TITLE SCALE
05.08.17		WEARSHOE 1:10
A	97:03:25	NEW ISSUE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT

D2656-13



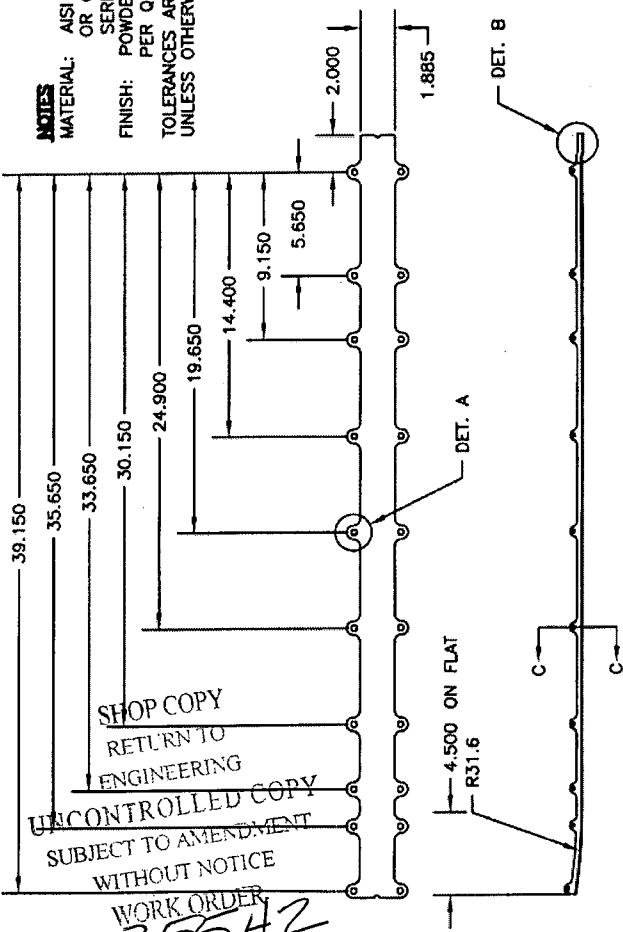
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NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GRAY SANTEX (.35.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

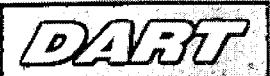
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D2656-15



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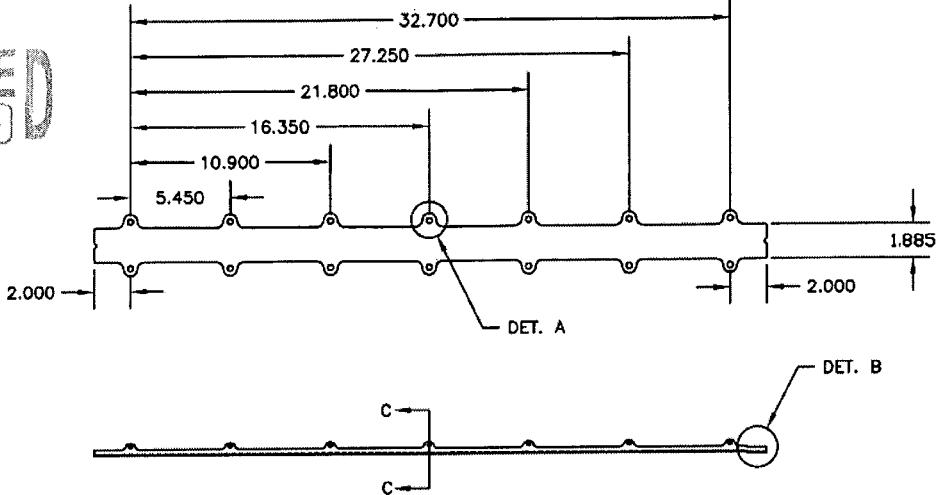
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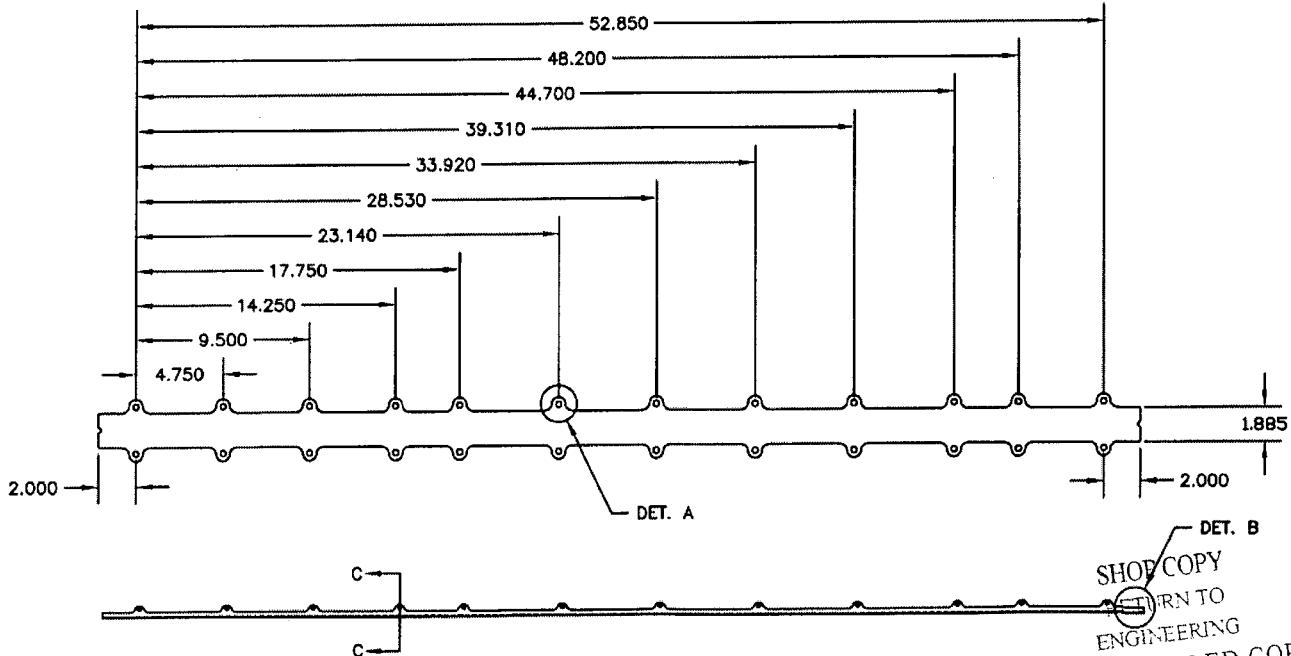
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DATE 05.08.17	TITLE WEARSHOE	REV. D SHEET 2 OF 4 SCALE 1:10

D2656-21

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05.07.06 *[Signature]*



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A368/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

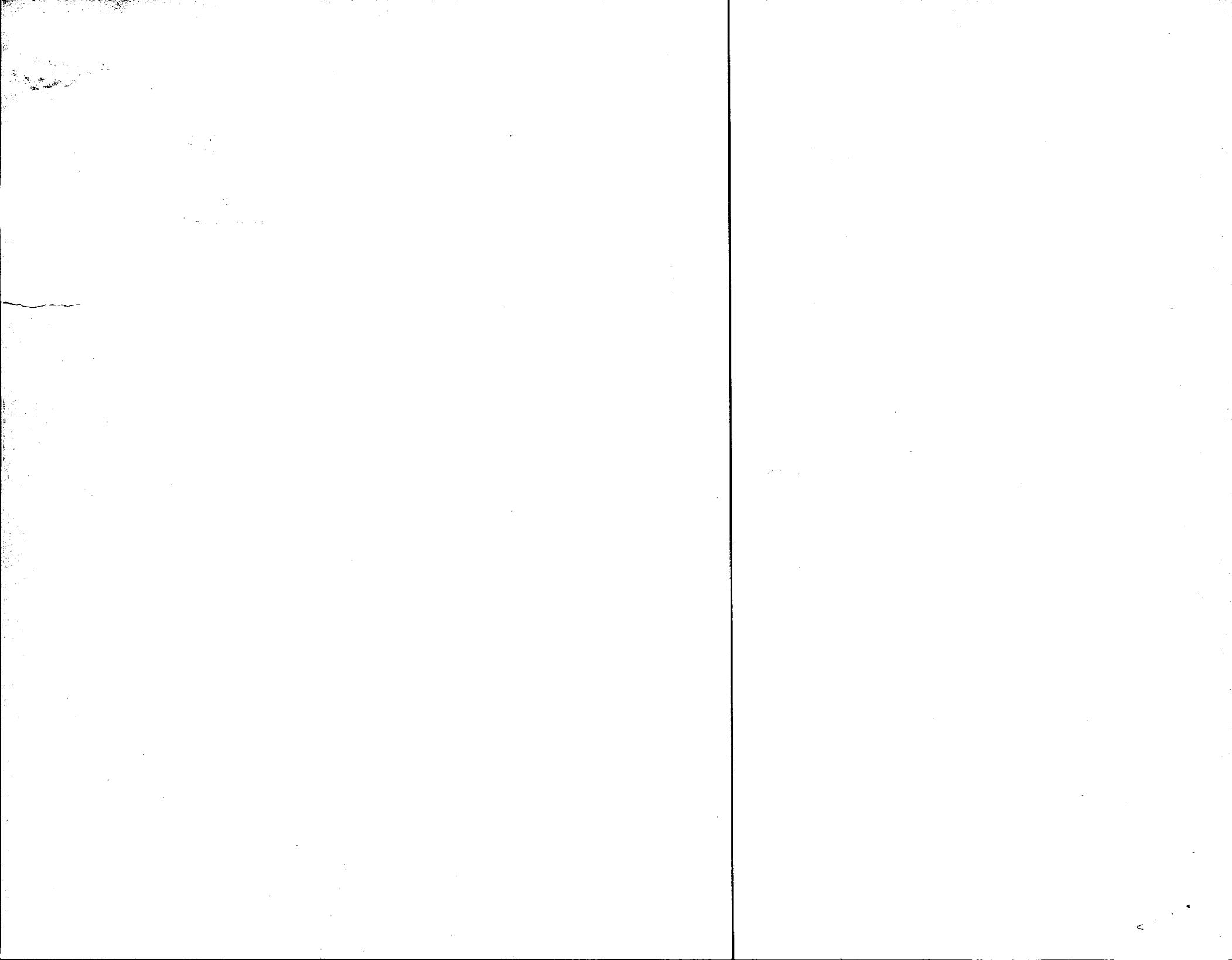
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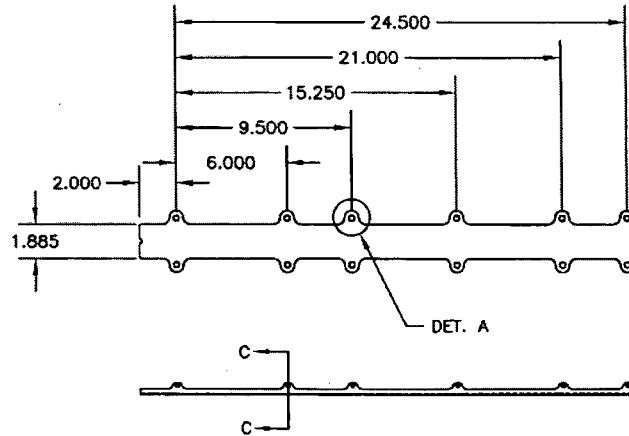
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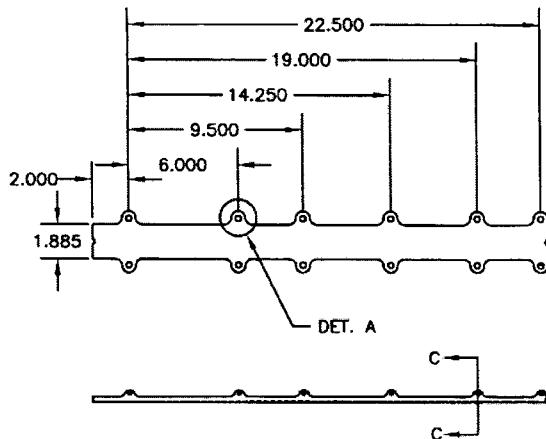
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SHEET 3 OF 4	1:10	SCALE		REV. D

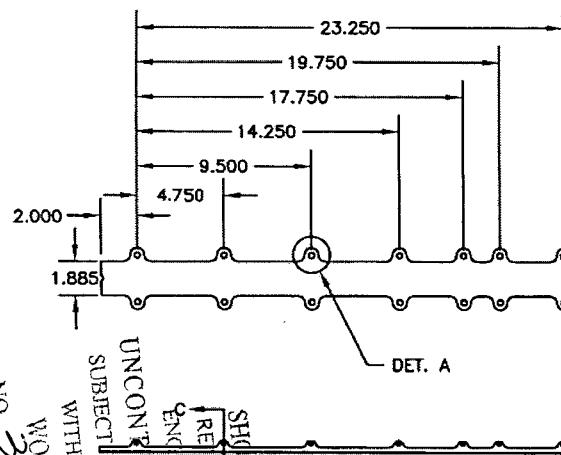
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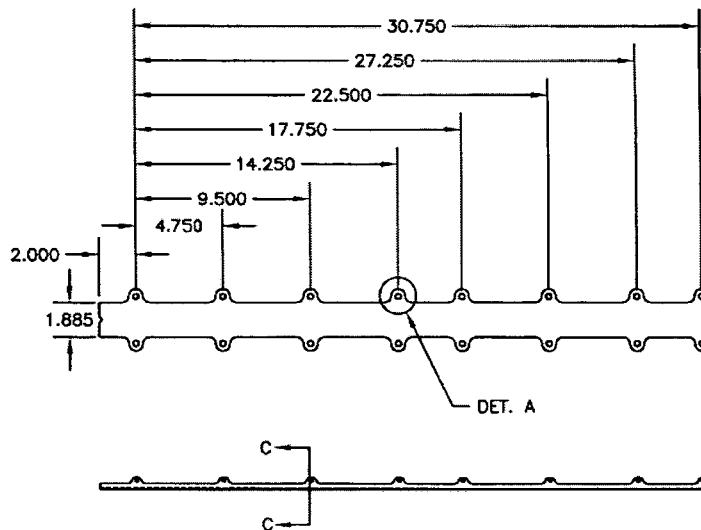
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D2656-35



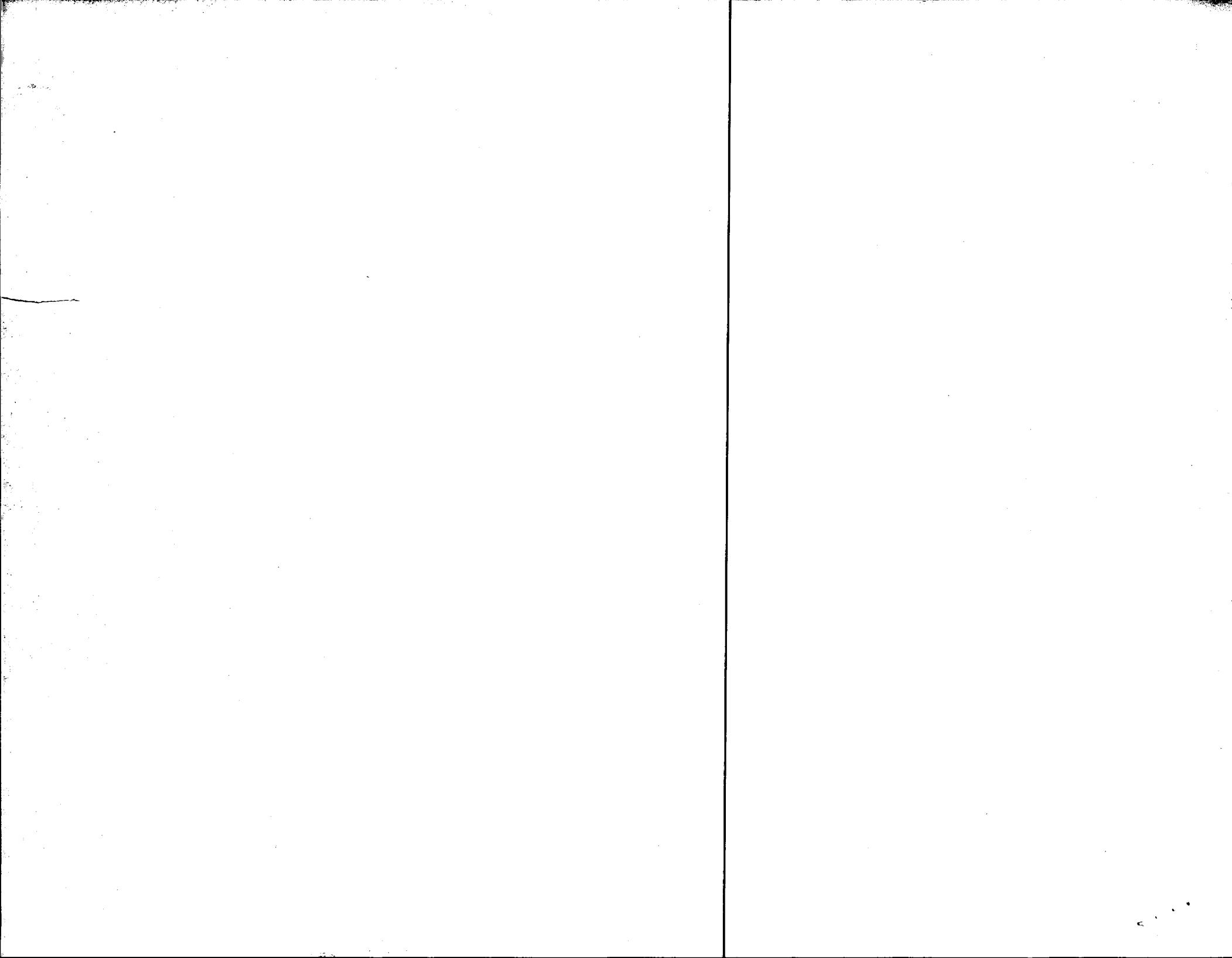
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SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

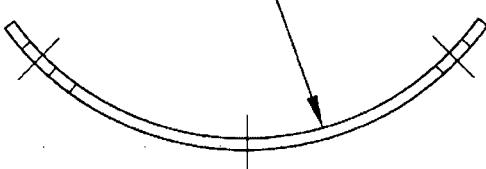
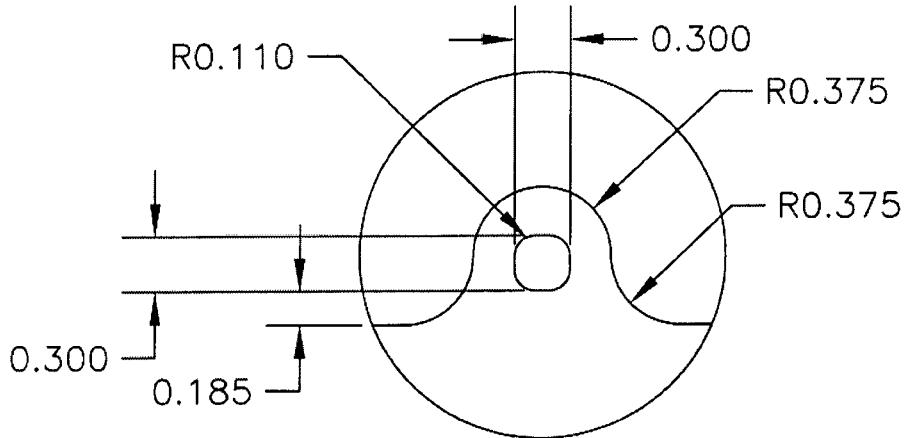
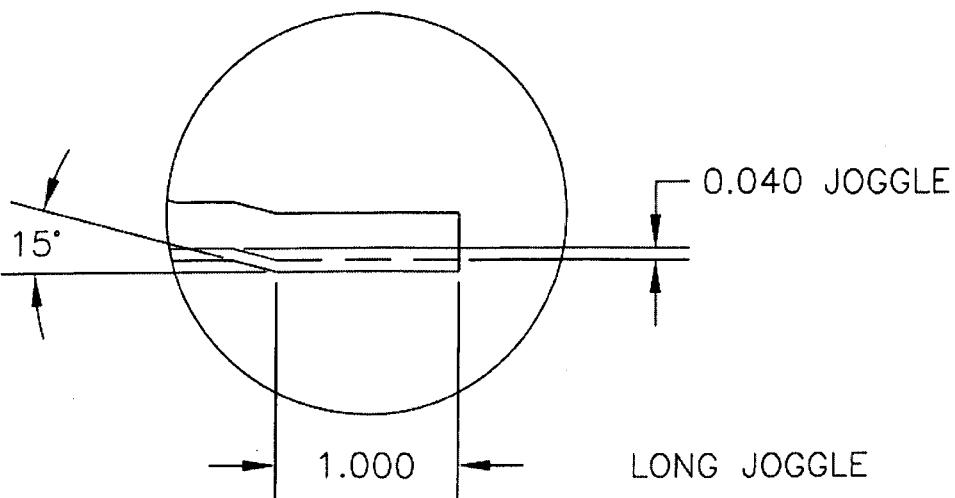


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

R1.62

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